

Work Order ID 72338

Friday, July 22, 2011 12:37:13 PM



Page 1

Item ID: D4331-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Doubler

Stop



Start Date: 7/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan:

mf

Date:

11-07-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4331

PA3

11-07-27

100



Waterjet

FLOW CNC Waterjet

PA3 FLOW WATER JET

0.00

0.00

Memo

1-Cut as per Dwg D4331 ☐

Dwg Rev: *PA3*

Prog Rev: *PA3* ☐

2-Deburr if necessary

PA 11/07/26

1

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

PA 11/07/26

1

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

PA 11-07-26 ①
AS Rv PA5

Work Order ID 72338

Friday, July 22, 2011 12:37:13 PM



Page 2

Item ID: D4331-1	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Doubler					
Start Date: 7/22/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 7/25/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00		SB 11/07/27		①			
Small Fab	FORM AS PER DWG								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00		AS per PA3 Dwg					
Quality Control									
160 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

1 φ BR 11-7-27.

Work Order ID 72338

Friday, July 22, 2011 12:37:13 PM

Page 3

Item ID: D4331-1

Accept

Revision ID: PRELIM

Item Name: Doubler

Start Date: 7/22/2011 Start Qty: 1.00

Required Date: 7/25/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11.07.20 AUTH

RELEASED DATE

72338

11.07.27

1 4 34 1107/27

11/7/27

Picklist Print

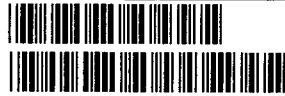
Friday, July 22, 2011 12:37:07 PM

Page 1

Work Order ID: 72338

Parent Item: D4331-1

Parent Item Name: Doubler





Start Date: 7/22/2011

Required Date: 7/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-05 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No				sf	202.1000		1.631579			
 													
2024-T3 .080 sheet													

Location Loc Qty Loc Code

MAT022	202.1	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	120	

1.8 JD 11/07/26

DART AEROSPACE LTD		Work Order: 72338
Description: Doubler		Part Number: D4331-1
Inspection Dwg: D4331 Rev: PA3		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.13	$\pm .030$	17.13	—		RA04	TAPE
14.50	$\pm .030$	14.50	—		"	
12.32	$\pm .030$	12.32	—		"	
10.50	$\pm .030$	10.50	—		RA04	TAPE
6.68	$\pm .030$	6.68	—		"	
4.92	$\pm .030$	4.92	—		"	
3.87	$\pm .030$	3.87	—		RA04	TAPE
3.28	$\pm .030$	3.28	—		"	
2.92	$\pm .030$	2.92	—		"	
2.13	$\pm .030$	2.13	—		"	
1.38	$\pm .030$	1.38	—		"	
.73	$\pm .030$.73	—		RA04	TAPE
.59	$\pm .030$.59	—		RA04	TAPE
.34	$\pm .030$.336	—		RA26	Turn
1.19	$\pm .030$	1.19	—		RA04	TAPE
1.25	$\pm .030$	1.25	—		"	
2.30	$\pm .030$	2.30	—		RA04	TAPE
3.30	$\pm .030$	3.30	—		"	
3.67	$\pm .030$	3.67	—		"	
12.30	$\pm .030$	12.30	—		"	
12.67	$\pm .030$	12.67	—		"	
13.05	$\pm .030$	13.05	—		"	
13.47	$\pm .030$	13.47	—		RA04	TAPE

Measured by: 	Audited by:	Prototype Approval:
Date: 11/07/26	Date:	Date:



Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

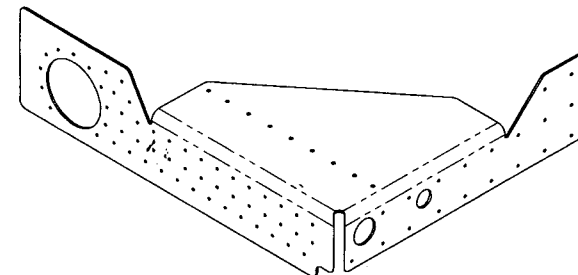
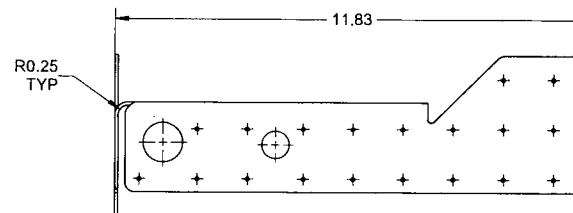
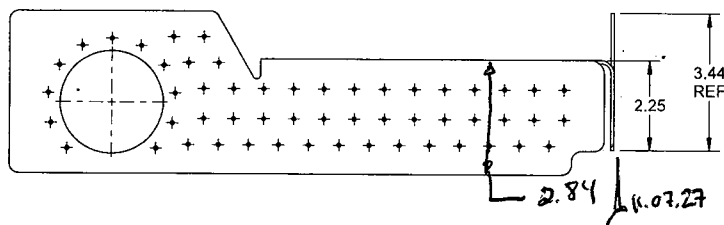
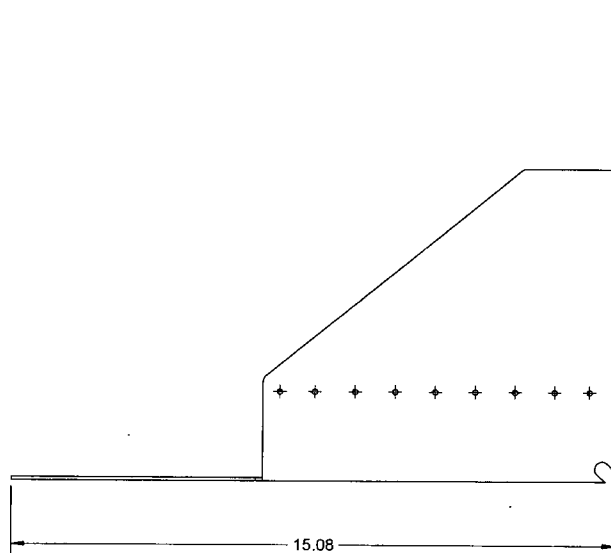
DART AEROSPACE LTD		Work Order: 72338
Description: Double R		Part Number: D4331-1
Inspection Dwg: D4331 Rev: PA.3		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.58	$\pm .030$	14.58	—		RA04	Tape
1.78	$\pm .030$	1.78	—		"	
2.38	$\pm .030$	2.38	—		"	
2.77	$\pm .030$	2.77	—		"	
3.42	$\pm .030$	3.42	—		"	
4.06	$\pm .030$	4.06	—		"	
4.92	$\pm .030$	4.92	—		"	
5.25	$\pm .030$	5.25	—		RA04	Tape
$\emptyset .129$	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.133	—		RA26	Vern
$\emptyset 2.56$	$\begin{matrix} +.012 \\ -.001 \end{matrix}$	$\emptyset 2.56$	—		RA26	Vern
$\emptyset 3.19$	$\begin{matrix} +.012 \\ -.001 \end{matrix}$	3.19	—		"	
$\emptyset .994$	$\begin{matrix} +.008 \\ -.001 \end{matrix}$.993	—		"	
$\emptyset .690$	$\begin{matrix} +.008 \\ -.001 \end{matrix}$.689	—		"	
$\emptyset .098$	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.101	—		"	
1.750	$\pm .010$					
1.250	$\pm .010$	1.243	—		RA26	Vern
1.000	$\pm .010$	1.002	—		RA26	

Measured by: 	Audited by: 	Prototype Approval:		
Date: 11/07/26	Date: 11.07.26	Date:		
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



#72335

D4331-1 DOUBLER

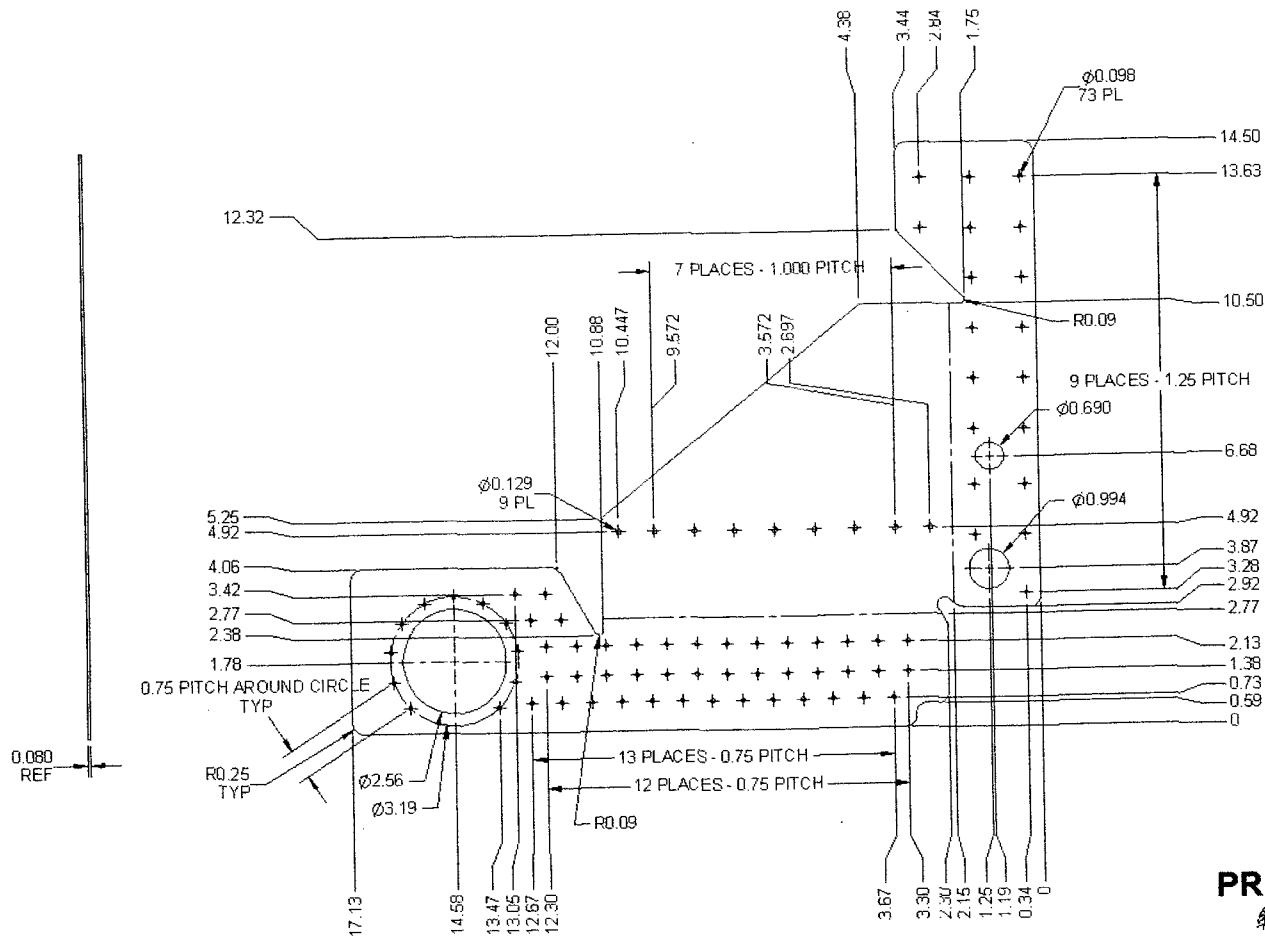
PRELIMINARY ISSUE

11.02.03

NOTES:

- 1) MATERIAL: MADE FROM D4331-1F
- 2) FINISH: PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4331	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.02.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



PRELIMINARY ISSUE
11.02.03

D4331-1F

- NOTES**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.072 THICK
REF DART SPEC M2024T3S072
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4331	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.02.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	